

Work Order ID 75857

75857

Page 1

Friday, November 18, 2011 10:06:45 AM

Item ID: K10111

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/9/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date: 11-18

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9583	A
K10111	B

100

0.00

100

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP K10111 CHG003
FOR D206-642-111 CHG007
FOR D206-642-113 CHG002

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

W 11 12 01 (4)
JF for MLS 11-11-24
(4)

11-11-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75857

75857

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Friday, November 18, 2011 10:06:45 AM

Item ID: K10111 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Skidtube 206
 Start Date: 11/1/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				<u>11</u>	<u>11</u>	<u>12</u>	<u>01</u> (4)
130 *130* Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP PPP D206-642-111 PPP D206-642-113 Location: <u>2A02 RT</u> PPP rev: _____	0.00 0.00 K10111							<u>11/12/12</u> (4)
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/12/15</u> (4)

11-12-2 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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75857

K10111

Required Date: 12/9/2011

Required Qty: 4.00

Comments: IPP: F01.11.08 Revised Step 5 and Added Inspection Level
21SM IPP REV:G
11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A		Purchased	No				Each	872.0000		16			
AN5-10A													
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337		872							
					116704	11							
					118191	59							
					119547	802							
AN5-11A		Purchased	No				Each	1,599.000		16			
AN5-11A													
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337		21							
					117313	2							
					118191	19							
				ST518		1578							
					119512	1578							
AN3-41A		Purchased	No			110	Each	1,655.000		32			
AN3-41A													
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st510		1655							
					119042	1655							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75857

75857

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A
AN4-6A
Bolt

Purchased No

110 Each 5,062.000 12 48

**

SP

Location

Loc Qty

Loc Code

ST356

62

119127

62

ST516

5000

119017

5000

110 Each

489.0000

1 4

**

SP

AN4C5A
AN4C5A
BOLT

Purchased No

Location

Loc Qty

Loc Code

FP-B

49

112243

49

ST355

440

112243

340

119017

100

110 Each

511.0000

2 8

**

SP

AN6-44A
AN6-44A
Bolt

Purchased No

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

504

119036

504

110 Each

1.0000

**

B 75480 SP 11-11-24

D206-651-041
D206-651-041
206A/B GHW

Manufactured No

Location

Loc Qty

Loc Code

FG125

1

74002

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Friday, November 18, 2011 10:06:50 AM

Work Order ID: 75857

75857

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2652

Manufactured No

110

Each

743.0000

16

64

D2652

Bushing

**

SP

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

Manufactured No

110

Each

18.0000

2

8

D2661-1

D2661-1

Saddle, LH Fwd Aft Out 206

**

B 7H473 5x
B 7H472 1x
11/11/30

Location

Loc Qty

Loc Code

MEZZ

5

64559

5

ST435

13

73838

10

73841

1

76516

2

Manufactured No

110

Each

20.0000

2

8

D2662-1

D2662-1

Saddle, LH In 206

**

2x
SP 11-11-24
2x B 7C/356
11/11/30

Location

Loc Qty

Loc Code

ST435

10

73846

1

74479

9

ST476

10

74481

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 75857

75857

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2712

D2712

Set Screw

Manufactured No

110

Each

2,551.000

10

40

**

SP

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

2501

71160

1

73837

500

76065

2000

40X

D2884

D2884

Saddle Spacer

Manufactured No

110

Each

100.0000

2

8

**

SP

Location

Loc Qty

Loc Code

FG

10

29453

10

ST025

90

73823

90

8X

D2885

D2885

Saddle Spacer

Manufactured No

110

Each

126.0000

2

8

**

SP 11-11-24

Location

Loc Qty

Loc Code

FG

10

29199

10

ST025

116

73824

116

8X

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 75857

75857

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D3413-1

Manufactured No

110

Each

94.0000

1

4

**

Sp

D3413-1

Ring

Location

Loc Qty

Loc Code

ST368

2

73821

2

4x

ST420

2

66387

1

70773

1

ST469

88

73822

88

ST473

2

71041

2

Purchased

No

110

Each

8,753.000

8

32

**

Sp 11-11-24

MS21042L3

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2498

119075

2498

32x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:06:50 AM

Work Order ID: 75857

75857

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

11,450.00

12

48

**

MS21042I 4

Nut

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5892

119017

5892

ST518

5000

119075

5000

MS21042L6

Purchased

No

110

Each

1,484.000

2

8

**

MS21042I 6

Nut

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

ST518

1000

119075

1000

NAS1149C0463R

Purchased

No

110

Each

1,379.000

1

4

**

NAS1149C.0463R

Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Friday, November 18, 2011 10:06:50 AM

Work Order ID: 75857

75857

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

4,434.000

8

32

NAS1149D0363.J

Washer

**

11/11/9537.80

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1418

117601

148

118077

1

118612

55

118968

1214

32x

NAS1149D0463J

Purchased

No

110

Each

12,582.00

24

96

NAS1149D0463.J

Washer

**

SP 11-11-24

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12258

119075

10000

119097

2258

96x

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Friday, November 18, 2011 10:06:50 AM

Work Order ID: 75857

75857

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

5,121.000

8

32

NAS1149D0563.I

Washer

**

SP

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3121

118206

2121

118614

1000

32x

NAS1149D0663J

Purchased

No

110

Each

2,598.000

4

16

NAS1149D0663.I

Washer

**

SP 11-11-24

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

16x

Friday, November 18, 2011 10:06:50 AM

Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY -113	QTY -114	QTY -151	QTY -149	PART NUMBER	DESCRIPTION
	X				D206-642-113	SKIDTUBE INSTALLATION, LH
		X			D206-642-114	SKIDTUBE INSTALLATION, RH
	1	1	X		D206-642-151	SKIDTUBE
				X	D206-642-149	RUN-ON LANDING WEARPLATE KIT
	1	1			D206-651-041	* 206 GHW ADAPTER ⁽²⁾
1			1		D3804-041	SKIDTUBE ASSEMBLY
2A			6		D2651-1	* PLUG ⁽¹⁾
2B			6		D2651-3	* O-RING ⁽¹⁾
3			1		D2646	* AFT CAP ⁽¹⁾
4			2		MS27039-1-08	* SCREW ⁽¹⁾
5			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1				D2661-1	SADDLE, FWD OUT, LH
6		1			D2661-2	SADDLE, FWD OUT, RH
7	1				D2662-1	SADDLE, FWD IN, LH
7		1			D2662-2	SADDLE, FWD IN, RH
8	1				D2661-1	SADDLE, AFT OUT, LH
8		1			D2661-2	SADDLE, AFT OUT, RH
9	1				D2662-1	SADDLE, AFT IN, LH
9		1			D2662-2	SADDLE, AFT IN, RH
10	8	8			AN3-41A	BOLT
11	16	16			D2652	BUSHING
12A	8	8			MS21042-3	NUT (OR MS21042L3)
12B	8	8			NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4			AN5-7A	BOLT
14	4	4			AN5-7A	BOLT
15	8	8			NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12			AN4-6A	BOLT
17	24	24			NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12			MS21042-4	NUT (OR MS21042L4)
20A			1	1	D3805-041	FWD WEARPLATE ASSY
21A			1	1	D3807-1	* GASKET ⁽³⁾
22A			1	1	D3805-045	AFT WEARPLATE ASSY
23A			1	1	D3807-5	* GASKET ⁽⁴⁾
26A			7	7	AN3-36A	BOLT
26B			7	7	NAS1149D0363J	WASHER (OR AN960JD10)
26C			7	7	MS21042-3	NUT (OR MS21042L3)
26D			14	14	D3873-1	BUSHING
27				2	D2649	SPACER
28	2	2			AN6-44A	BOLT
29A	2	2			MS21042-6	NUT (OR MS21042L6)
29B	4	4			NAS1149D0663J	WASHER (OR AN960JD616)
34	1	1			AN4C5A	BOLT
35	1	1			NAS1149C0463R	WASHER (OR AN960C416)
36	1	1			D3413-1	RING
37	10	10			D2712	SET SCREW
38	2	2			D2884	SPACER
39	2	2			D2885	SPACER

- NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3804-041 ASSEMBLY ABOVE
(2) NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS
(3) DENOTES THAT PART IS INCLUDED WITH D3805-041 ASSEMBLY ABOVE
(4) DENOTES THAT PART IS INCLUDED WITH D3805-045 ASSEMBLY ABOVE

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. O AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 4

REF FAA STC: SA00475SE

REF CANADIAN STC: SH98-4

REF EASA STC: EASA.IM.R.S.01320

PROCEDURE:

FOR D206-642-113/-114 SKIDTUBE INSTALLATION KITS, IT HAS BEEN DETERMINED THAT AN5-10A (FWD) AND AN5-11A (AFT) BOLTS ARE MORE APPROPRIATE BOLT LENGTHS FOR ATTACHING THE SKIDTUBES TO THE CROSSTUBES THAN THE AN5-7A BOLTS PREVIOUSLY PROVIDED IN THE KITS.

4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

32.12 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
			D206-642-113	SKIDTUBE INSTALLATION, LH
			D206-642-114	SKIDTUBE INSTALLATION, RH

IS:

13	4	4	AN5-10A	BOLT
14	4	4	AN5-11A	BOLT

WAS:

13	4	4	AN5-7A	BOLT
14	4	4	AN5-7A	BOLT

FOR FURTHER DETAILS REFER TO PAGE 22, DETAIL A OF IIN-D206-642 REV. O, OR PAGE 30, DETAIL A OF ICA-D206-642 REV. 4.

A	NEW ISSUE	AJS	11.11.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC KENT, WA	
DRAWN	AJS		
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9583	SHEET 1 OF 1
APPROVED	10	TITLE	SCALE
DE APPR.	11	BOLT SUBSTITUTION	NTS
DATE	11.11.02	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	